



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3389-1**Job Sheet 193568****Part No:** D3389-1**Job Qty:** 10 pcs**Part Name:** Web**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 4/16/19**Job Tracking No:****Due Date:** 4/19/19**Created By:** Marie Lajeunesse**Type:** SOLD**Description:**

Note: DWG REV D IPP Rev:A 05.08.31 New issue KJ/JLM IPP Rev:B 06-02-08 As per Rev C JLM IPP Rev:C 07-11-13 ECN 1056 Rev D dwg DD verified by:EC

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Skidtubes - 1	10 pcs	4/19/19	0.00 6.06			Skidtubes - 1		
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		TF
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
110	QC 5	10 pcs	4/19/19	0.00 0.00			QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		BE
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
120	Handfinish - 1-1 Chemical-B4B	10 pcs	4/19/19	0.00 2.16			Handfinish - 1 - 1 - B4B		
							Handfinish - 1 - 2 - B4B		
							Handfinish - 1 - 3 - B4B		
							Handfinish - 1 - 4 - B4B		
							Handfinish - 1 - 5 - B4B		
							Handfinish - 1 - 6 - B4B		



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1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

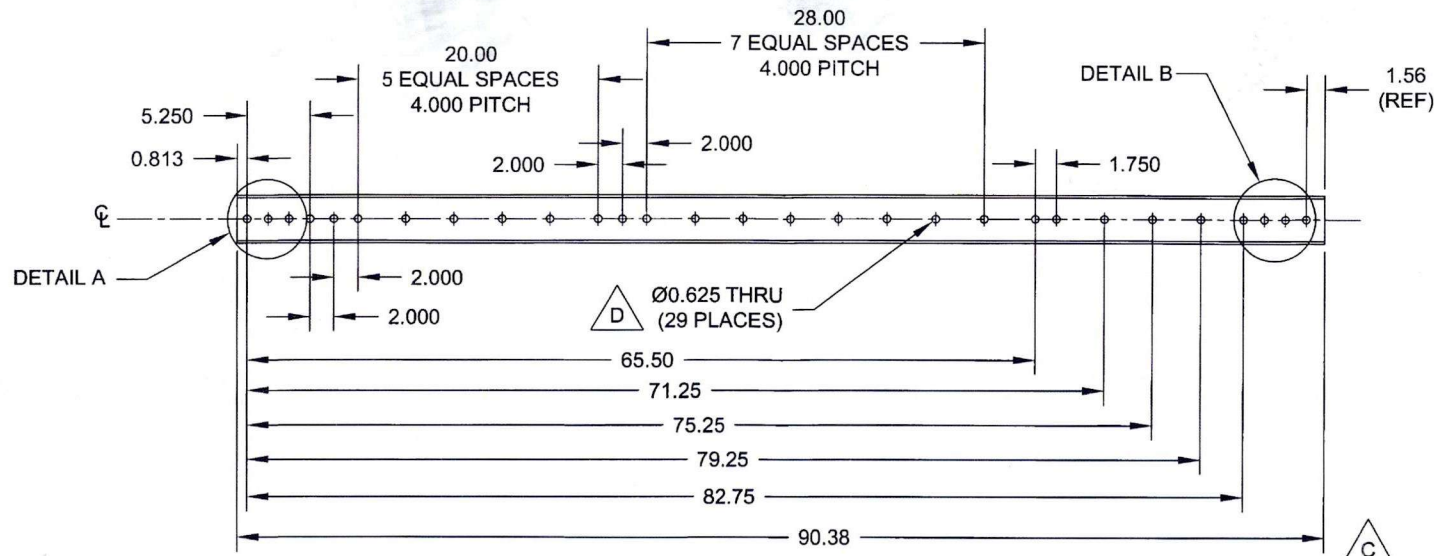
Container No: S176317**Part:** D3389-1**Job No:** 193568**Serial No/Batch:** S176317**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's**Date:** 04/29/19

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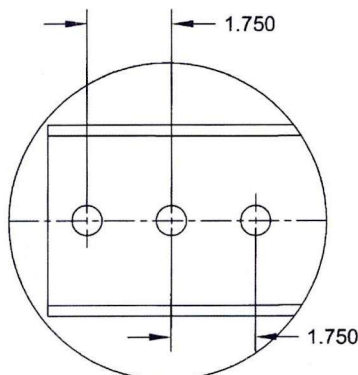
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	D.R 19/04/01
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
130 QC 7	10 pcs	4/19/19	0.00	0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	mba
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
140 Packaging 3-1 - Stock - B4B	10 pcs	4/19/19	0.00	0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
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					Packaging 3 - 7 - B4B				
					Packaging 3 - 8 - B4B				
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					Packaging 3 - 22 - B4B				
					Packaging 3 - 23 - B4B				
					Packaging 3 - 24 - B4B				
					Packaging 3 - 25 - B4B				
					Packaging 3 - 26 - B4B	TF			
					Packaging 3 - 27 - B4B				
					Packaging 3 - 28 - B4B				
					Packaging 3 - 29 - B4B				
					Packaging 3 - 30 - B4B				
					Packaging 3 - 31 - B4B				
					Packaging 3 - 32 - B4B				
					Packaging 3 - 33 - B4B				
					Packaging 3 - 34 - B4B				
					Packaging 3 - 35 - B4B				
					Packaging 3 - 36 - B4B				
150 QC 21 - SA	10 pcs	4/19/19	0.00 0.00	QC 21 - SA - 21	DAG	MAY 01 2019			
				QC 21 - SA - 70	21				
				QC 21 - SA - 53	9-38				
Part Op 100 - (Skidtubes) 1- Pick D2500-3-100 3- Locating from deburred end, drill pilot holes using DT8785 as per dwg D3389. Descriptions: Scribe cut line. 4- Cut to finished length 5- Open holes to finished size as per dwg D3389 6- Deburr 110 - (QC5- Inspect part completeness to step on W/O) 120 - (Chemical Conversion Coat per QSI005 4.1) 130 - (QC7-Inspect Chemical Conversion Coat) 140 - (Identify as per dwg & Stock Location: _____) LOCATION : LG002 150 - (QC21- Final Inspection - Work Order Release)									
Job BOM									
Part / Item	Component Name	Quantity	Operation	Container					
D2500-3-100	Ext'n -I' Beam Web 4"	10 pcs (1 ea)	100-Skidtubes - 1	5083738 x4					
				5166539 x6					
Job Allocations									
Operation	Component Part	Required	Inventory	Allocated					
100-Skidtubes - 1	D2500-3-100	10	185	0					
Part Specifications									
Specifications could not be found.									

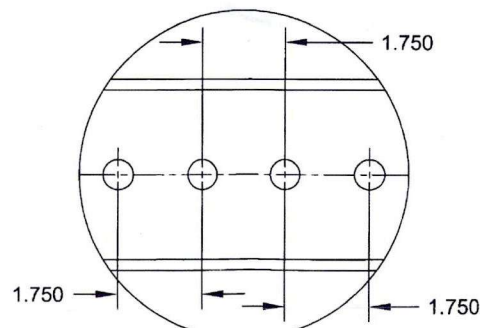
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D3389-1 412 WEB



DETAIL A
SCALE 2:5



DETAIL B
SCALE 2:5

NOTES:

- 1) MATERIAL: MAKE FROM D2500-3 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 6.6 lbs

RELEASED
07.11.06

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 193508 H65
19-04-16

D	REVISE HOLE DIAMETER FROM Ø0.257 TO Ø0.625, ZONE D4; REFORMAT DRAWING	PH	07.10.09
C	DECREASE OVERALL LENGTH, MODIFY HOLE	PH	06.01.23
B	UPDATE DIMENSIONING	PH	05.06.13
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.10.09		

DART AEROSPACE USA, INC	
PORT HADLOCK, WA	
DRAWING NO. D3389	REV. D
TITLE 412 WEB	SHEET 1 OF 1
SCALE 1:10	
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